

DART AEROSPACE LTD		Work Order:	22740
Description: D2306 rework as a D2304		Part Number:	D2304
Dwg:		Qty:	1
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller			
2	QC	Remove D2306 B#4277 from stores	HT	05.04.22	1
3	GA	Remove D2317 / D2342 from D2306	HT	05.03.15	1
4a	GA	Rework D2303 as per Dwg D2319	HT	05.03.16	1
5	GA	Rework D2302 as per Dwg D2313	HT	05.03.16	1
6	QC5	Inspect level 5	HT	05.04.18	1
7	FP	Repowder Coat as per QSI005	HT	05.04.18	1
8	QC3	Inspect level 3	u	05.04.21	1
9	ST	Identify and stock as D2304 B#22740	u	05.04.21	1
4b	GA	Install rivet ⁸⁴⁷ DMS20426 AD4-21 M#102	HT	05.03.16	1
10	AC	Close 393.35	HT	05.04.22	1
10	DC	Close w/o inspect level 21	HT	05.04.22	1

Rev	Date	Change	Revised By	Approved
A		New issue		

DESCRIPTION: 204 Aspirator Assembly		IPP- Batch No: 4277
		Part No: D2306
		Qty: 45
Step	Location	Procedure
1	EXPEDITION	

Step	Location	Procedure	By	Date
1	EXPEDITING	Issue W/O		
2	Stores	Pick Kit		
		BATCH #		
	1 D2302	B3864	UCB	9/6/04/12
	1 D2303	B3850	UCB	9/6/04/12
	1 D2295	B3840	UCB	9/6/04/12
	1 D2375-4-16-163	M810	UCB	9/6/04/12
	1 D2301	M2312	UCB	9/6/04/12
	1 D2294	B3839	UCB	9/6/04/12
	1 D2281-1	B3847	UCB	9/6/04/12
	1 D2281-3	B3847	UCB	9/6/04/12
	1 D2317	B3852	UCB	9/6/04/12
	1 D2334	B3811	UCB	9/6/04/12
	1 D2342	B3849	UCB	9/6/04/12
	1 D2307-1	4255	UCB	9/6/04/12
	4 AN3-3A	R1548 4 M1498	UCB	9/6/04/12
	8 AN9603D10	R1484	UCB	9/6/04/12
	7 MS20600ADPW5	M21400	UCB	9/6/04/12
	23 MS20600ADPW6	M2099	UCB	9/6/04/12
	6 MS20470AD4-5	M2338	UCB	9/6/04/12
	4 MS21042L3	R1502	UCB	9/6/04/12
	2 NAS 1329A3K80	M2405	UCB	9/6/04/12
	METAL	ASSEMBLY AS PER D2306	CDW	9/6/04/12
	Q.C.	INSPECT	CDW	9/6/04/12
	STORES	BAG & TAG	CDW	9/6/04/12
	EXPEDITING	CLOSE W/O	UCB	9/6/05/24
			UCB	9/6/05/24

Dwg D2306 incl.

Dng D2306 incl.

75.20

MANUFACTURER RELEASE CERTIFICATION

The aeronautical product de
condition for safe operation.

D.O.T Approval 9-89

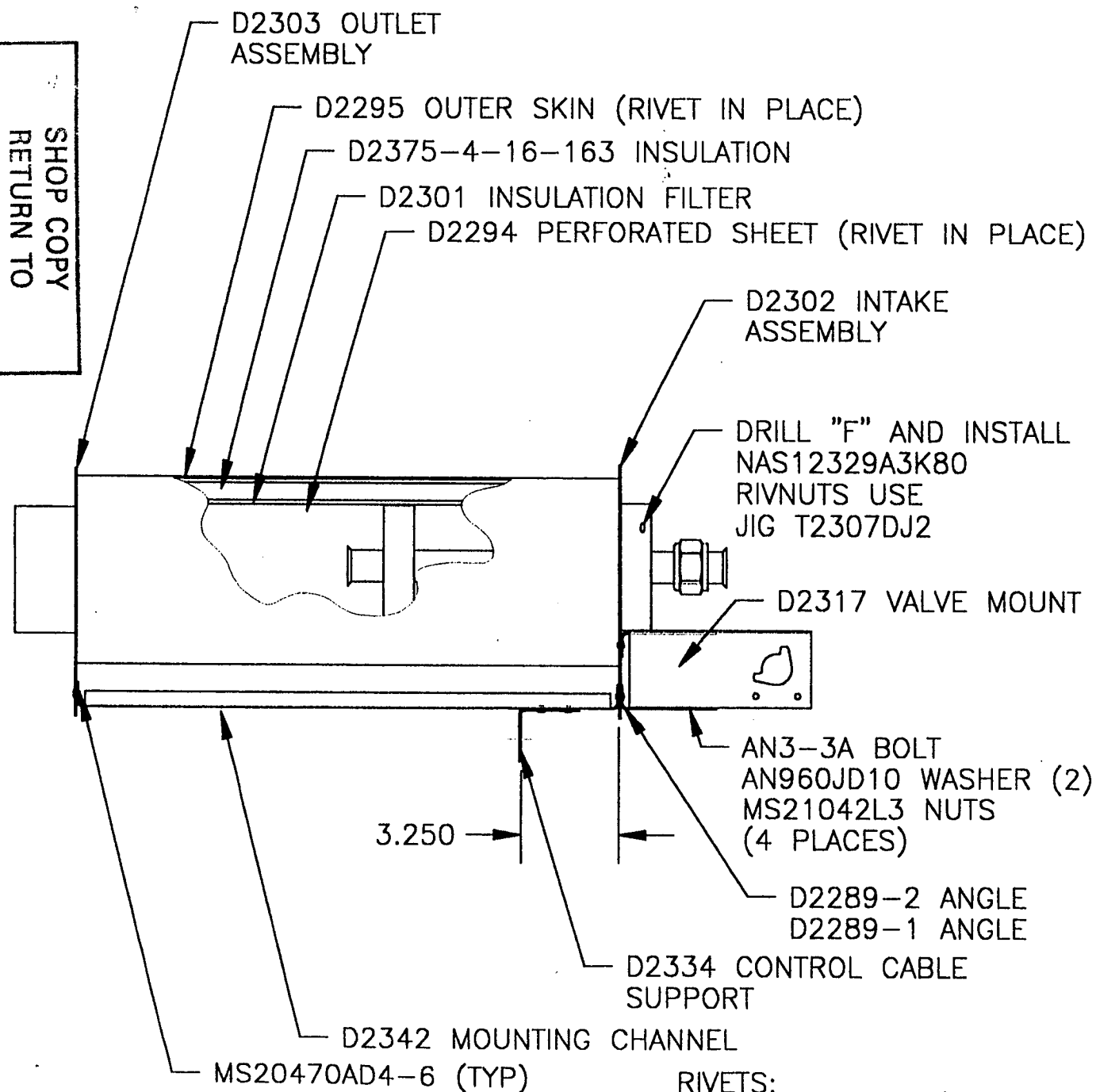
Authorized Inspector

Date _____

96/08/30

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RETURN TO
ENGINEERING

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RIVETS:
MS20600AD4W5 SHF
MS20600AD4W6

DATE
95.01.03

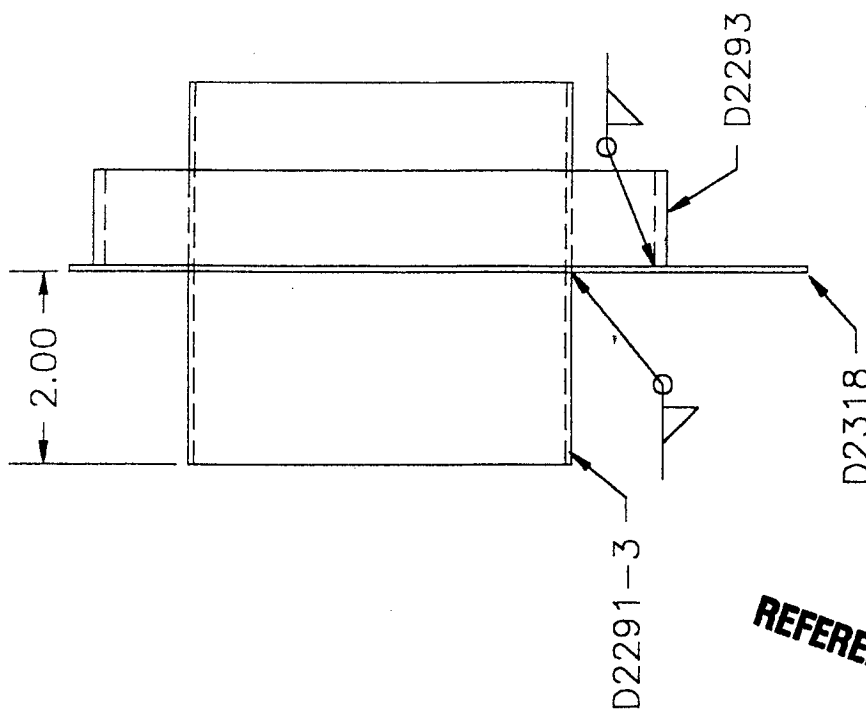
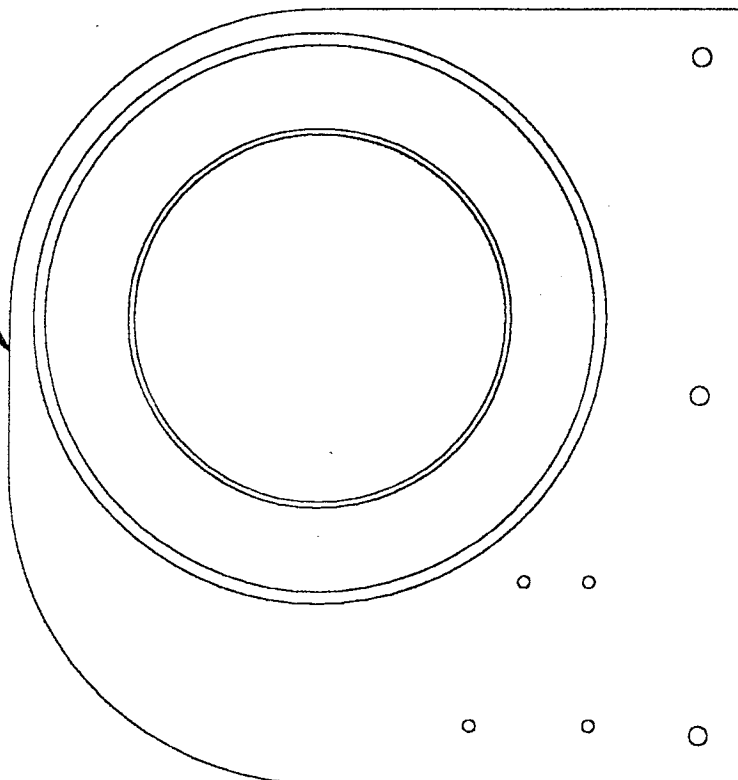
TITLE
B204 ASPIRATOR ASSEMB

CONTROLLED COPY



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
BW	BW	D2303	SHEET 2 OF 2
DATE	TITLE		SCALE
94.11.02	OUTLET WELDMENT ASSEMBLY		

D2318



FINISH: ANODIZE

REFERENCE ONLY

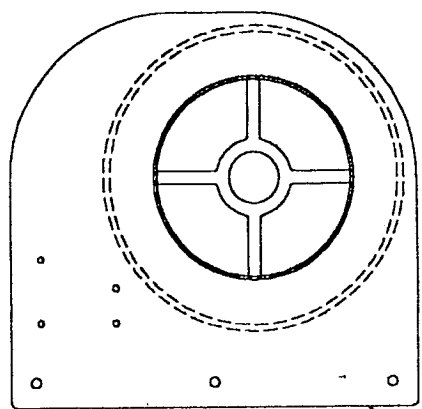
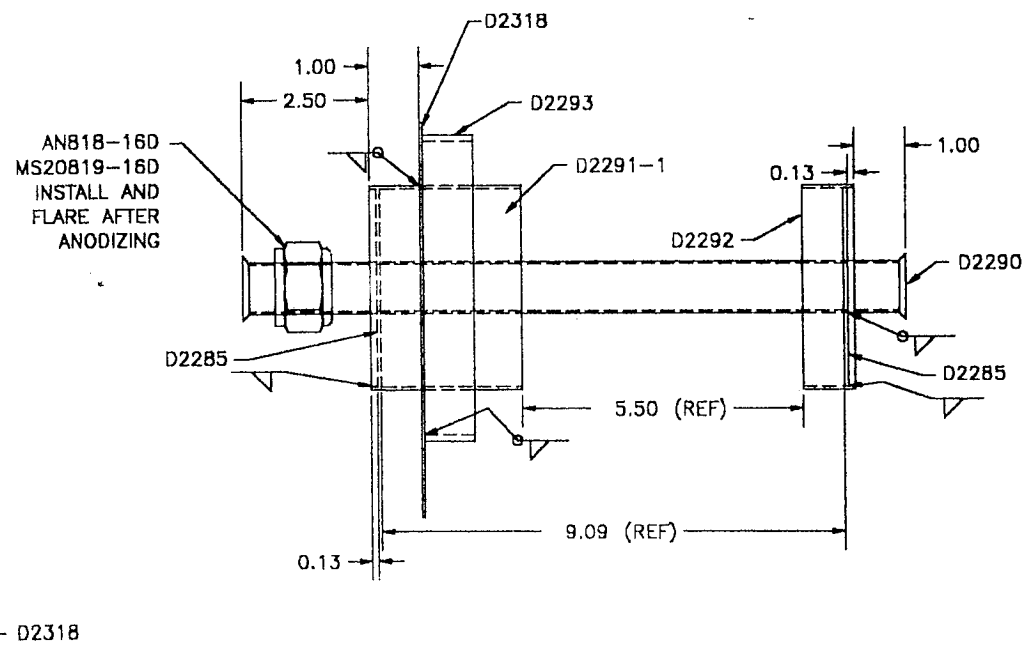
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DART



REFERENCE ONLY

DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	BW	APPROVED	BW	
DATE	94.10.25	TITLE	D2302	INTAKE WELDMENT ASSEMBLY
		REV. E	SHEET 2 OF 2	SCALE



D2318

FINISH: ANODIZE

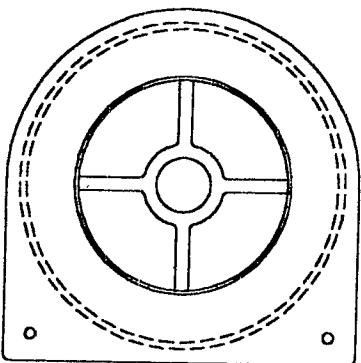
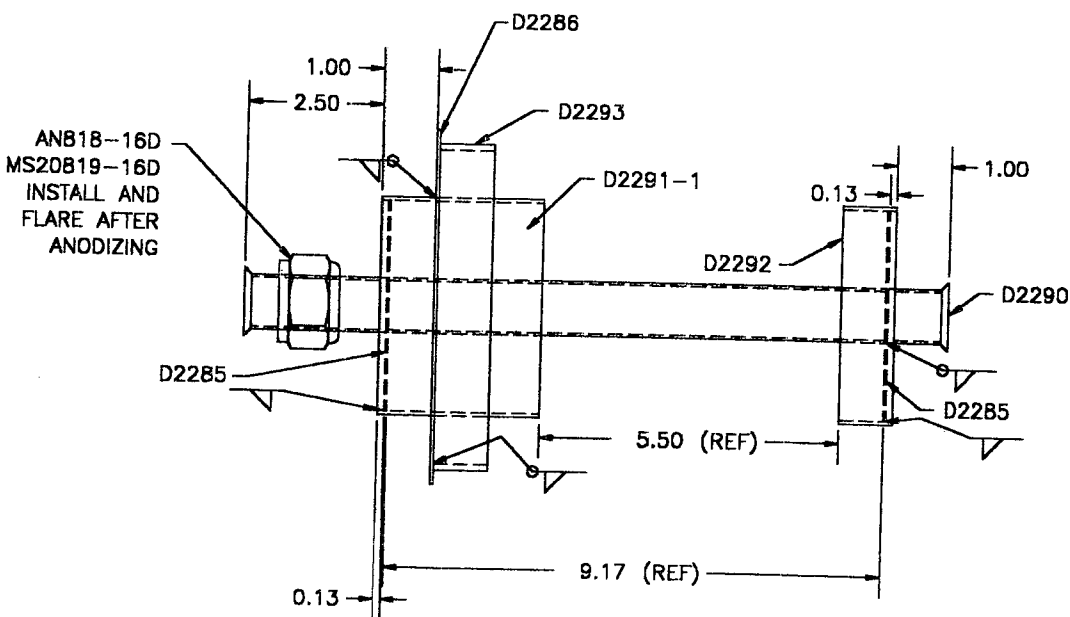


PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED 	APPROVED 	D2313	REV. D SHEET 1 OF 2
DATE Jan. 10, 1995		TITLE INLET WELDMENT ASSEMBLY SCALE	
D	96:04:18	MODIFIED MASTER PARTS LIST	

QTY	Part No.	Description
X	D2313	INTAKE WELDMENT ASSEMBLY
2	D2285	LOCATOR CROSS
1	D2289	END PLATE
1	D2290	JET PIPE
1	D2291-1	4" RING
1	D2292	4" RING
1	D2293	6" RING
1	AN818-16D	FLARE NUT
1	MS20819-16D	SLEEVE

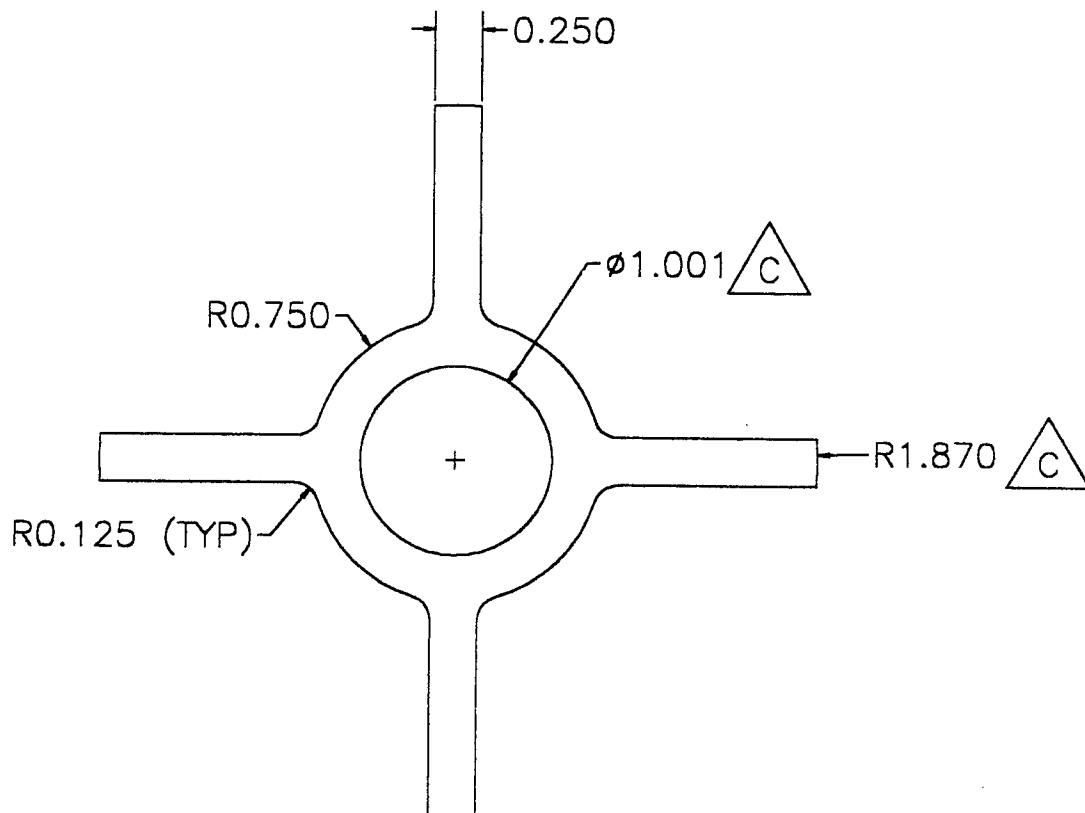


PREPARED	B. Williams	DART AERO ACCESSORIES INC
CHECKED		VICTORIA INTERNATIONAL AIRPORT, CANADA
APPROVED		
DATE	Jan. 10, 1995	TITLE
		D2313
		INLET WELDMENT ASSEMBLY
		REV. D
		SHEET 2 OF 2
		SCALE





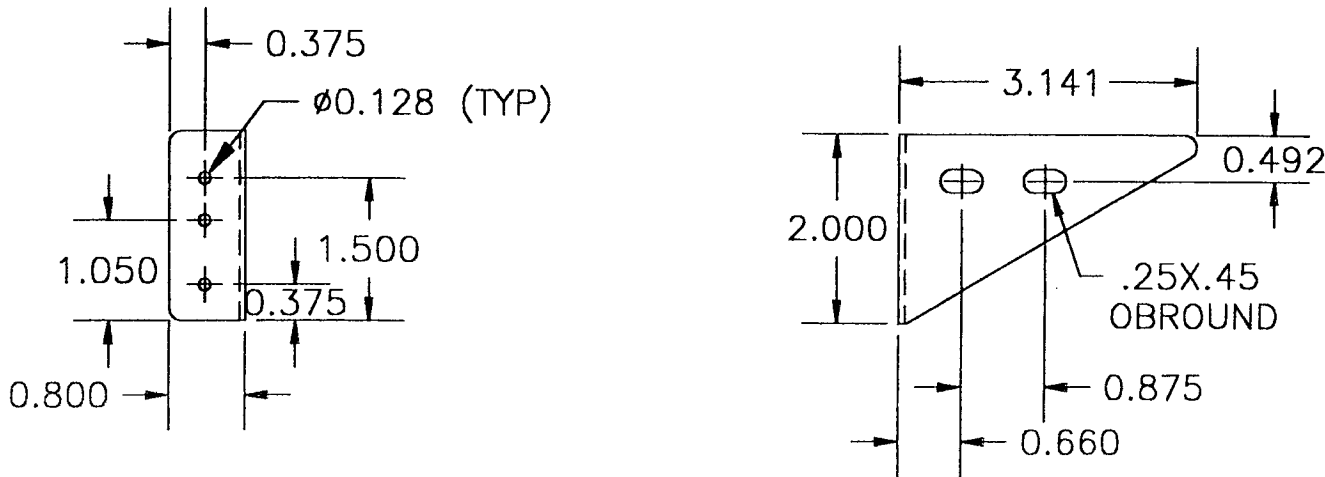
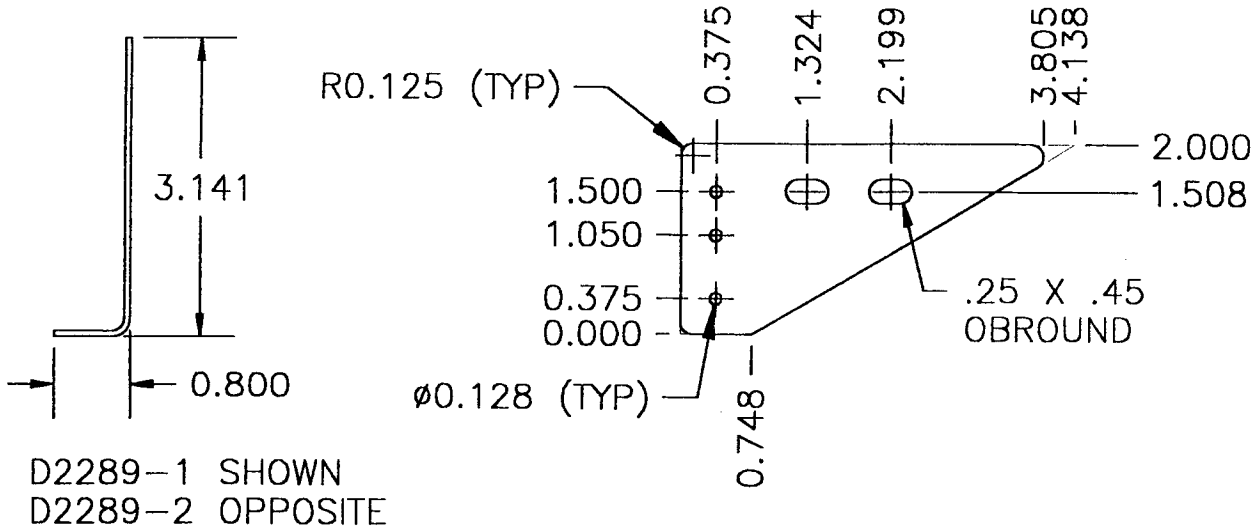
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B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C
CHECKED Bw	APPROVED Bw	D2285	SHEET 1 OF 1
DATE	TITLE		SCALE
94.21.21	HEATER TUBE LOCATOR		1:1
B	Nov. 7, 1994	CHANGED ARM ENDS	
C	96.01.15	CHANGED DIMENSIONS	



MATERIAL: 5052-H34 0.080 THICK



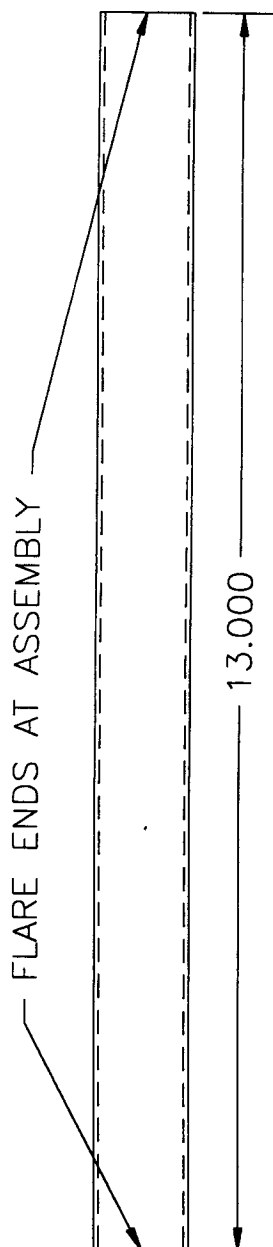
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CHECKED	BW	APPROVED	BW	DRAWING NO. D2289	SHEET 1 OF 1
DATE	94.12.21	TITLE	VALVE MOUNTING BRACKET	SCALE	1:2
C	96.01.15	CORRECTED FLAT PATTERN			



BEND RADIUS: 0.125
MATERIAL: 5052-H34 0.063 THICK



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	D2290	REV. A SHEET 1 OF 1
DATE Oct. 25, 1994		TITLE 1" HEATER TUBE SCALE	



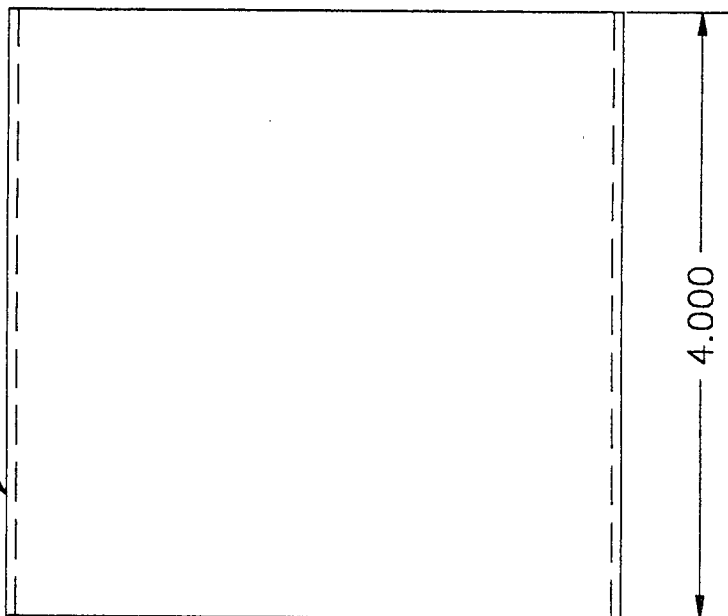
12'
10/25/94
198/10/1

MATERIAL: 6061-T6 SEAMLESS TUBE
1" DIAM 0.049 WALL CUT 13" LONG

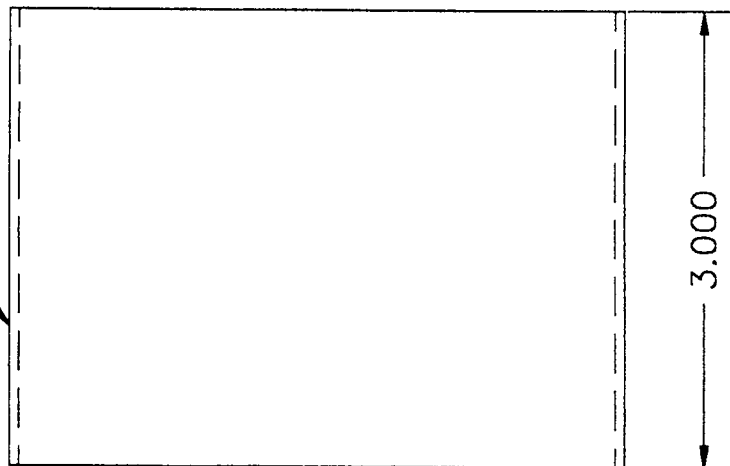


DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2291	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 4" HEATER TUBES	
B	96.01.15	CHANGED MATERIAL	

D2291-3



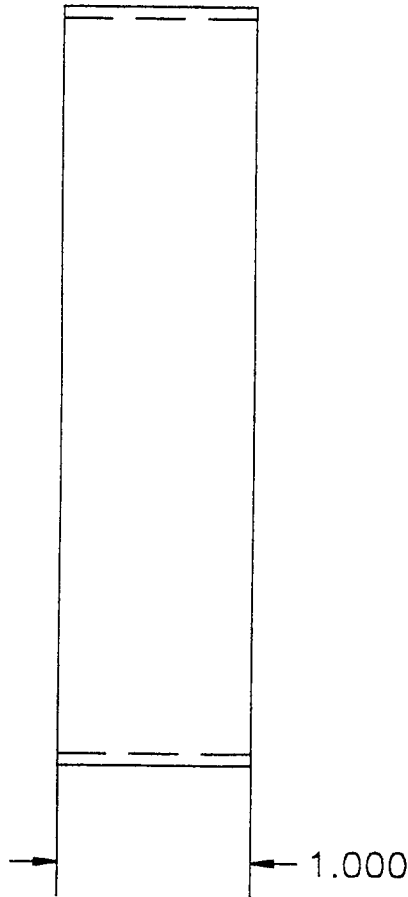
D2291-1



MATERIAL: 6061-T6 TUBE
4" OD X 0.125 WALL



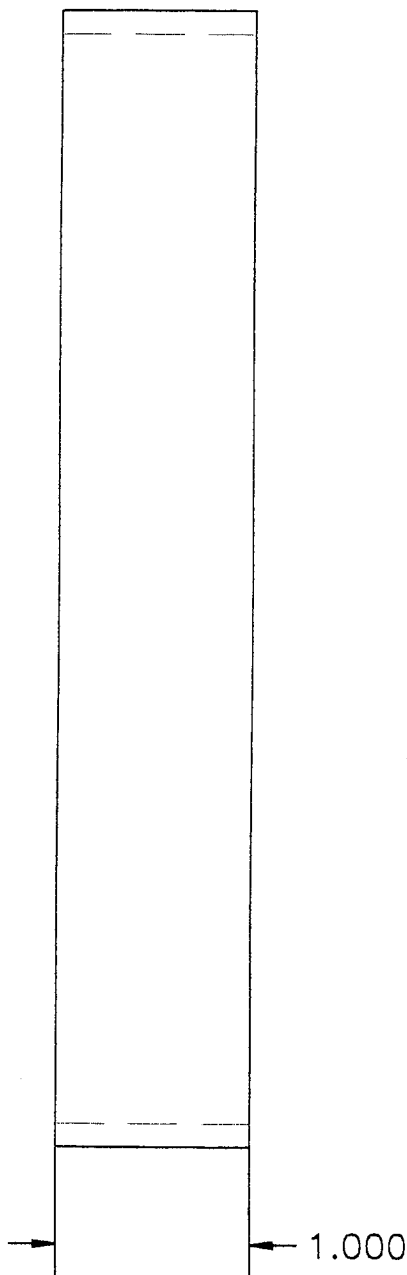
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CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2292	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 4" HEATER TUBE	SCALE 1:1
B	96.01.15	MATERIAL WAS 0.063 WALL	



MATERIAL: 6061-T6 TUBE
4" OD X 0.125 WALL CUT 1" LONG



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2293	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 6" HEATER TUBE	SCALE 1:1
B	96.01.15	CHANGED MATERIAL	



12' = 17.61 / ft 23 wks
24' = 12.92 / ft 1-2 wks

MATERIAL: 6061-T6 TUBE
6" DIAM 0.125 WALL CUT 1" LONG



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	D2319	REV. B
DATE Jan. 10, 1995		TITLE OUTLET WELDMENT ASSEMBLY	SHEET 2 OF 2 SCALE

